



Dart Aerospace Ltd.
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D3914-041
Job Sheet 169500



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/31/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/30/18	0.00	0.00	Start Up Large Fab-5		Dr 2018-02-13
100	Large Fab	1 pcs		1/30/18	0.00	6.67	Large Fab 1		PC 18-2-13
110	QC	1 pcs		1/30/18	0.00	0.00	QC9		CPL
120	QC	1 pcs		1/30/18	0.00	0.00	QC5		CPL
130	Powdercoat	1 pcs		1/30/18	0.00	0.40	Powdercoat4		Dr 18-02-16
135	QC	1 pcs		1/30/18	0.00	0.00	QC3		BEB 18-02-16
140	HandFinish	1 pcs		1/31/18	0.00	0.80	HandFinish3		BEB 18-02-16
150	QC	1 pcs		1/31/18	0.00	0.00	QC3		SB
160	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3-2		DAS SB
170	QC21-SA	1 Ea		1/31/18	0.00	0.00	QC21		21

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***

M 138700 START: 9:30 O.V.T. 320° Finish: 10:00

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5033599	2	51	0	0
	D3914-1 5034699	2	16	0	0
	D3914-7 5032228	2	16	0	0
	D4016-3 5038793	3	49	0	0
	D4018-5 5035012	9	27	0	0
	D4020-5 5029997	1	6	0	0
	D4021-3 5032438	1	11	0	0
	D4035-043 5041480	2	18	0	0
	D2728-3	1	0	0	0
140-HandFinish					

Part Specifications

Specifications could not be found.

Master Unit 000581



Job No 169500



Container No: S042107



Part: D3914-041

Serial No/Batch: S042107

Revision: D4020, D3914

Inspector:

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